



TECNICAL BULLETIN 2

Hi All,
as part of our support to your sales of **Dumor** machines we send out from time to time a technical bulletin.

The preceding Technical Bulletin nr 1 was about the sticking upper position finger on the Multi Air, all these machines were corrected in November.

This bulletin is about the multi air also with detailed information and general use information.

TECHNICAL BULLETIN NR 2

1 Upgraded infeed side guides now fitted

These will better guide the paper at infeed and ensure a more accurate line position on light stock.

Since December all new deliveries are fitted with 4 HD magnet side guides. These offer about triple the grip as the older guides which had 2 weaker magnets. This is especially for heavier paper that tries to kick the side guide out of position.

Upgraded top guides supplied

Also the machines are equipped with longer paper top guides for light stock which tends to lift away from the tray and skew, the new guides keep the paper on the right path and in contact with the side guides at all times.

The deliveries of October and November have already been issued with the upgraded parts.

If you have a earlier machine that has sheet guidance problems contact me.

As a reminder sheets should be fed in short edge first to get the proper result long edge first infeed will lead to skew...

2 Position of back register plate : Possible gap

The multi has a stainless steel register plate that can be adjusted for skew by a knob. In a few cases the factory set the plate too low and a gap of 2 or 3 mm could be seen between the suction belt box and the rear plate. In this case it could happen that if the skew is oriented heavily to the left that the sheet might lift and enter the gap and become momentarily unguided and then loose line accuracy. In this case the rear plate can be adjusted upwards.

TO DO SO:

1. Unplug
2. Remove the rear cover
There are several screws holding the rear plate mounting sub frame to the main frame, they are in slots.
3. The screws can be loosened and the guide raised until the gap is closed off
4. Then tighten the screws
5. Close the cover

3 Getting a correct line accuracy result

I have found on many occasions that client and dealers say the machine is not accurate enough, even with the correct guides and settings.

In every case it is because the client had paper that is not usable in any make of machine.

eg not:

- Square,
- and/or even on the sides ,
- and/or parallel,
- and/or even in the pile width
- and/or extremely curled

We would remind you that **for any print finishing machine that is required to give a precise line position that the paper has to be :**

- Flat
- Square front end vs register side
- Parallel sided in length and in pile width
- Smoothly cut on the front edge and the sides

**Copy paper and paper from mills has a 5 pct cut tolerance and is not accurate!!!
Don't trust it!!!**

Usually we find that the waviness error is from poor storage > unwrapped or over cooked the copier. Wavy paper will hit the blade and damage the edge and skew.

For the geometric errors, they arise due to:

- A old cutter with worn blade carrier guides.
- A cutter with blunt blade, also making hooked edges and trouble feeding.
- Incorrect knocking up of the paper.
- Backgauge or side lay out of square.

So before you complain about the machine, Please check the paper using a steel set square (not a plastic one)

4 measuring the line accuracy

I have found that many dealers do not know how to check of the line is accurate and repeatable. There are plenty of wrong ways to "check it" eg fanning the pile like a deck of cards and looking at it

there is 1 right way=>

I explain the right way:

1. Get a fresh pile of paper (not already creased!!!) that is tested for squareness and accuracy of cut and is flat.
2. Get a quality steel set square.
3. Put the paper in **SEF** (SHORT EDGE FIRST)
4. Correctly set the side guides and top guides so the pile is correctly square and stacked.
5. Put a sheet in the reception tray to let the follow on slide in without catching.
6. Run several sheets (about 10 to 15 is enough) with 3 or 3 lines at say 50, 100, 150mm.
7. Take the pile noting which end and side is which. Set on a level table and knock up along the back side and front edge.
8. Lock the sheets tightly.
9. From the sides look at the lines for overlay, the creases should fit into one another on both sides.
10. If you want to check for skew, do a half way crease and then split the pile and turn the top part and stack on the bottom part.
(*The paper has to be precisely cut on all sides for this to work!!!*)
11. For length checking use a steel rule from the front edge. The measurement is to the center of the crease line.

12. Paper length shrinkage.

Note that if you do several creases on a sheet the overall **length of the sheet may decrease by several mm** due to the paper being displaced by and into the crease line.

Take this into account if you are making book covers !!!

5 Use of the cross perf bar

The multi can be fitted with a cross perf bar.

As for the crease bar the press height can be adjusted for the perf bar. Some users think that more depth = better

NOT SO:

- If you are already getting a decent perf do not increase the depth !
- If you do then you will just cut into the platen and destroy it in short order, some users have actually managed to cut it in half !
- So for the height adjustment, if it works => *Don't touch it !*

6 New type of platen

The material used on the platen has been altered and made more durable by a factor of about 4x.

The new material is slightly green with crosses, the old material was transparent. The price remains the same.

As the platen is a wear part it is not covered in the warranty

Improving all the time...

Dumor crew

WE WISH YOU
A
MARRY CHRISTMAS
&
a *Happy* New
YEAR